

Work Order ID 58735

Tuesday, May 18, 2010 8:52:44 AM



Page 1

Item ID:	D4034-3	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib				Stop	
Start Date:	5/18/2010	Start Qty: 3.00		Cust Item ID:		
Required Date:	5/25/2010	Req'd Qty: 3.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10-5-18	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4034	A								

100		0.00							
Large Fab	Memo	0.00							
Large Fab	1- Cut tube as per dwg D4034 2- Drill and chamfer holes as per dwg use DT9560								

SAD 10-06-10

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

8 10 06 10

120	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo	0.00							
Packaging									

SAD

10-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58735

Tuesday, May 18, 2010 8:52:44 AM



Page 2

Item ID: D4034-3

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 5/18/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10
MF

10-6-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 18, 2010 8:52:48 AM

Page 1

Work Order ID: 58735



Parent Item: D4034-3



Parent Item Name: Rib

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	380.4845	1.4375			
304 SQ Tube .75x.75x.049W												



SAD

10-06-10

Location	Loc Qty	Loc Code
MAT	247.7189789	
113763	0	
114323	46.0489789	
114677	201.67	
MAT017	132.7655368	
113763	24.25	
114298	108.515537	

m114835

→ 4.5394

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

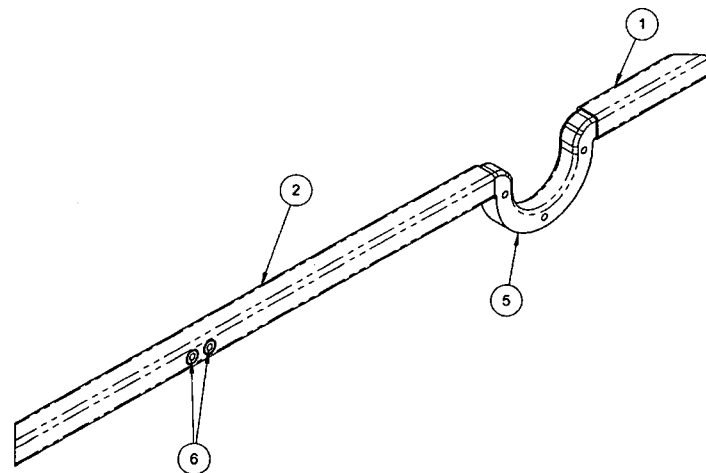
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

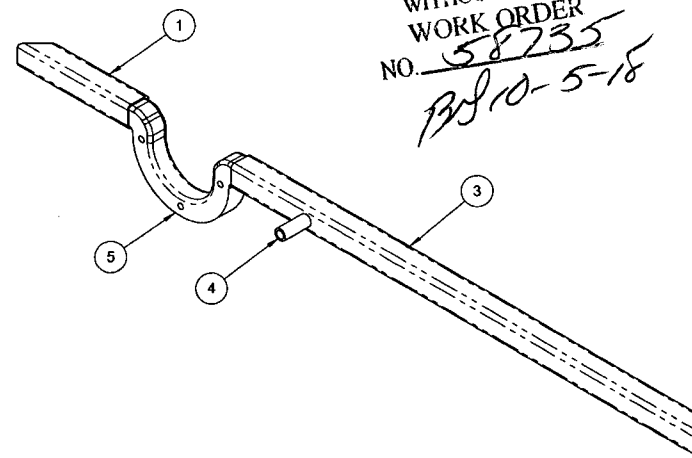
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	2		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58735
BS10-5-18

RELEASED
2010-03-12
MP

A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

D4034-3
RIB

C

C

25.00

4 PL

G

D4021-9
BUSHING
2 PL

D4034-041 AFT UPPER RIB ASSY

D4021-7
HOOP

D4034-1
RIB

B

B

RELEASED
2010-03-12
JMP

WLO 55735

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.59 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>g</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>E</i>	D4034	SHEET 2 OF 4
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>#</i>	UPPER RIB ASSY, BASKET BASE	
DATE	10.03.04	NTS	
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8 7 6 5 4 3 2 1

A

A

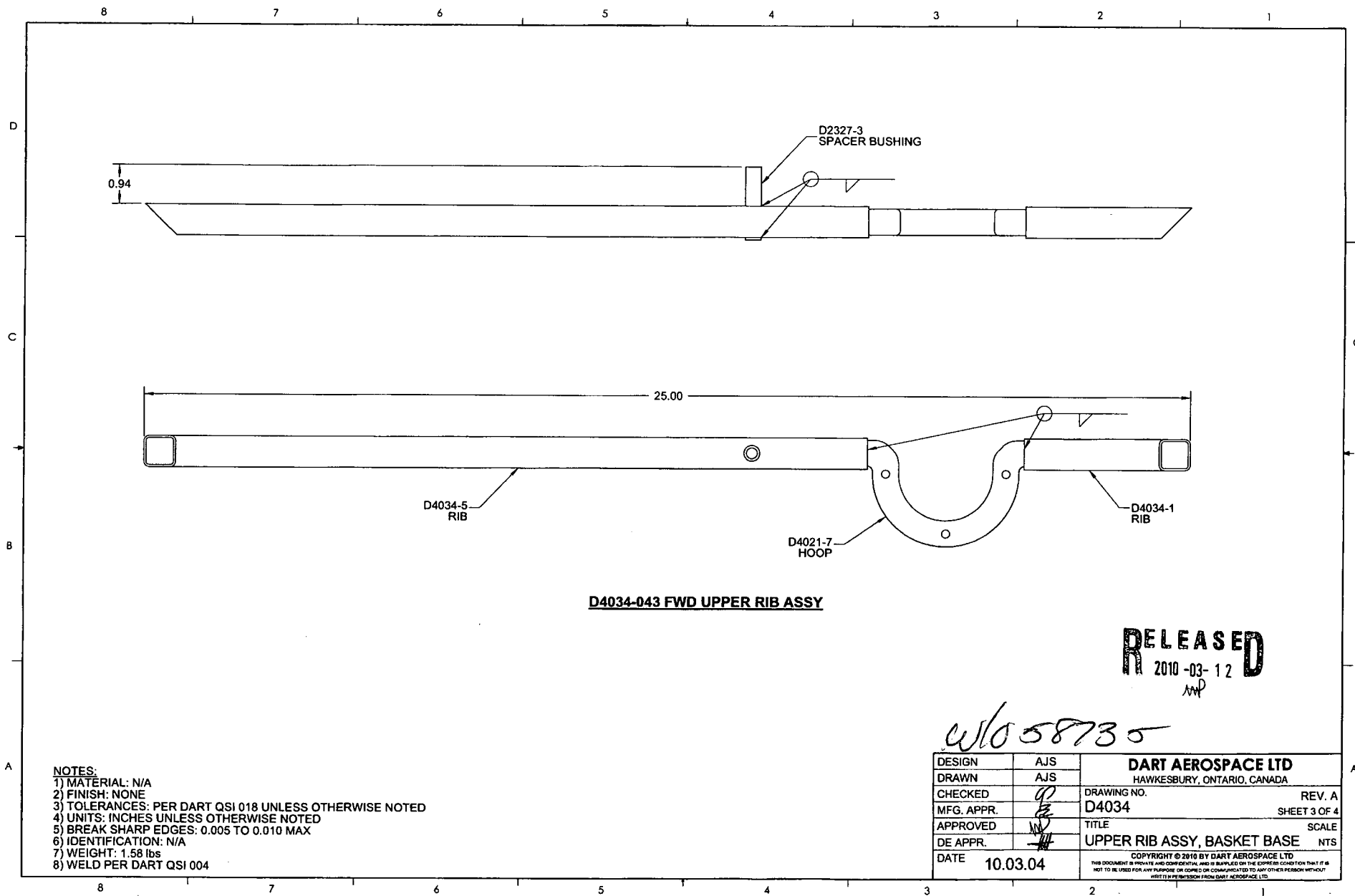
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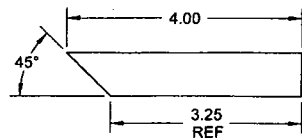
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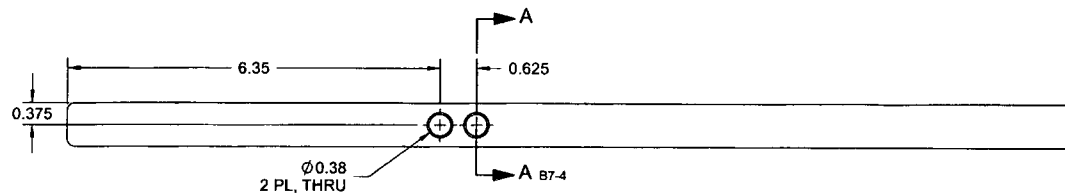


D4034-1 RIB

BREAK EDGE
0.030 X 45°
TYP



SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
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RELEASED
2010-03-12
[Signature]

W1058735

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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